

# Work Order ID 66599

Tuesday, February 22, 2011 1:28:57 PM



Page 1

Item ID:	D3188-6	Accept		Setup	Start	
Revision ID:						
Item Name:	Spacepod Body				Stop	
Start Date:	2/22/2011	Start Qty: 1.00		Cust Item ID:		
Required Date:	2/25/2011	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-02-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3188	Rev F								

100	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								

11. 07. 06 (13)

110	Identify as per dwg & Stock Location: <u>composites</u>	0.00							
Packaging	Memo	0.00							
Packaging									

11 07 06

120	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/6   
MF

11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, February 22, 2011 1:29:02 PM

Page 1

Work Order ID: 66599

Parent Item: D3188-6

Parent Item Name: Spacepod Body




Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-05 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3188-2M  SPACEPOD BODY RH		Manufactured	No		66602	100	Each	1.0000	1	1		BT 11-04-06	

Location

Loc Qty

Loc Code

CA

1

46180A

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

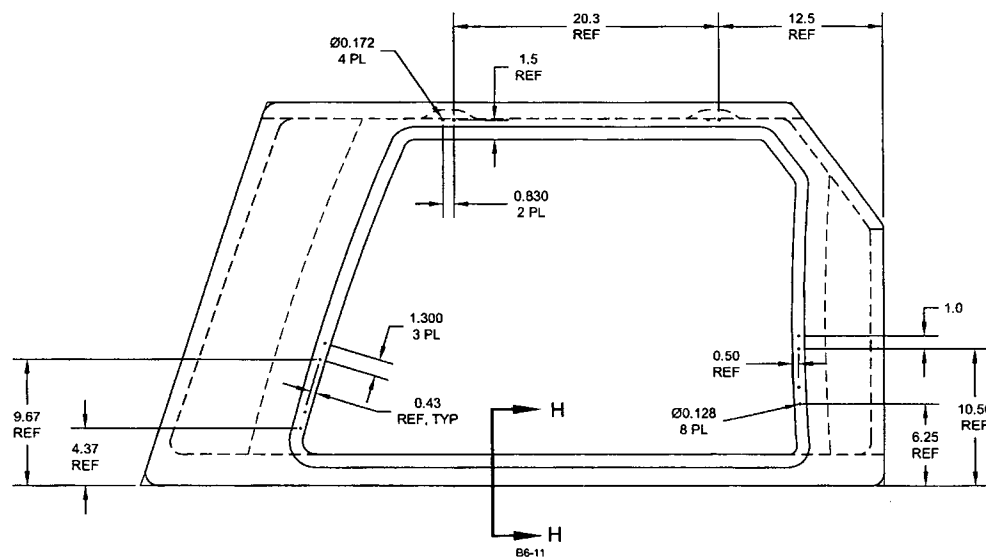
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 64399

11-02-02

RELEASED  
2009-10-20

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	#	D3188	SHEET 1 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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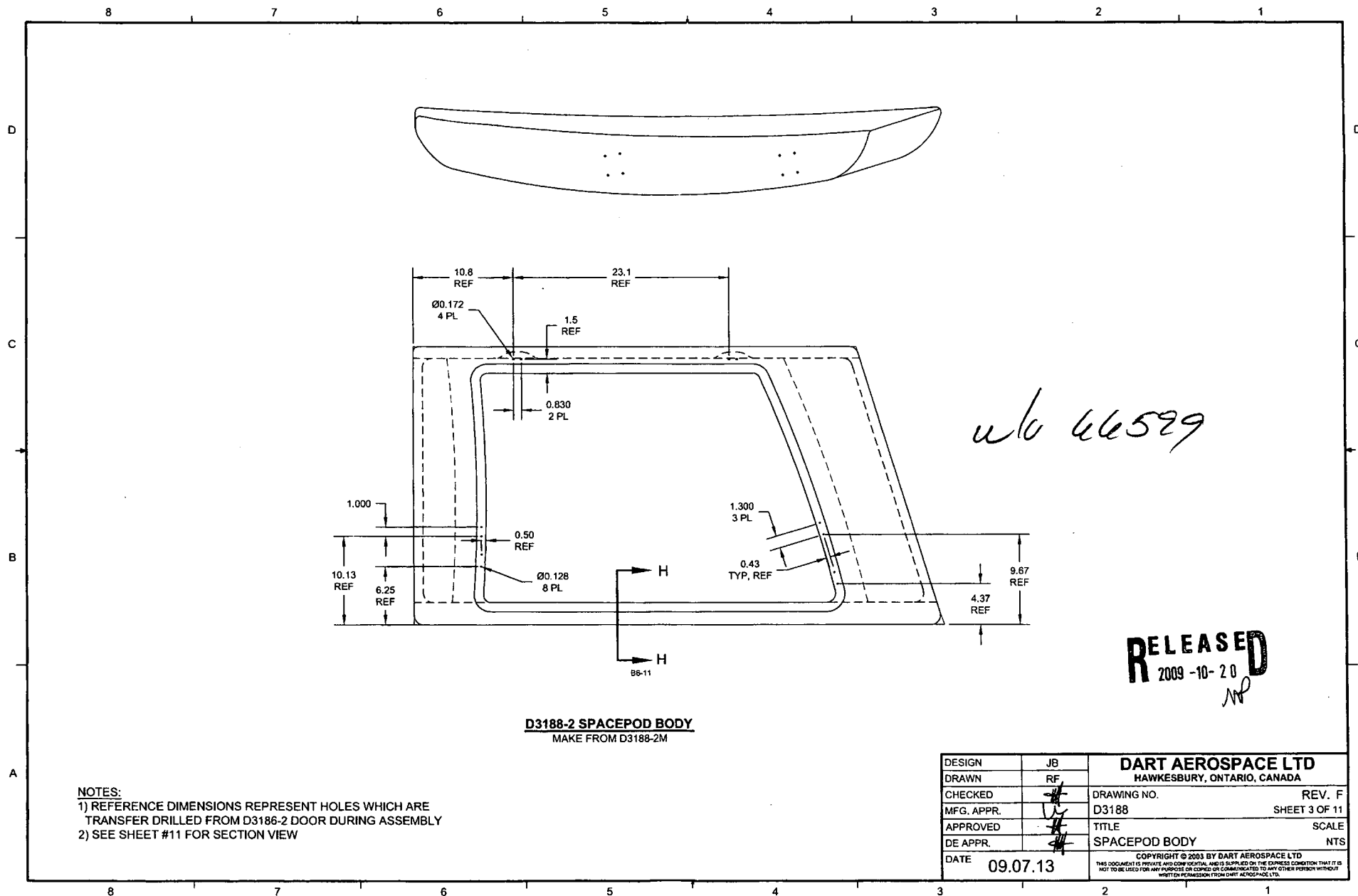
w/066589

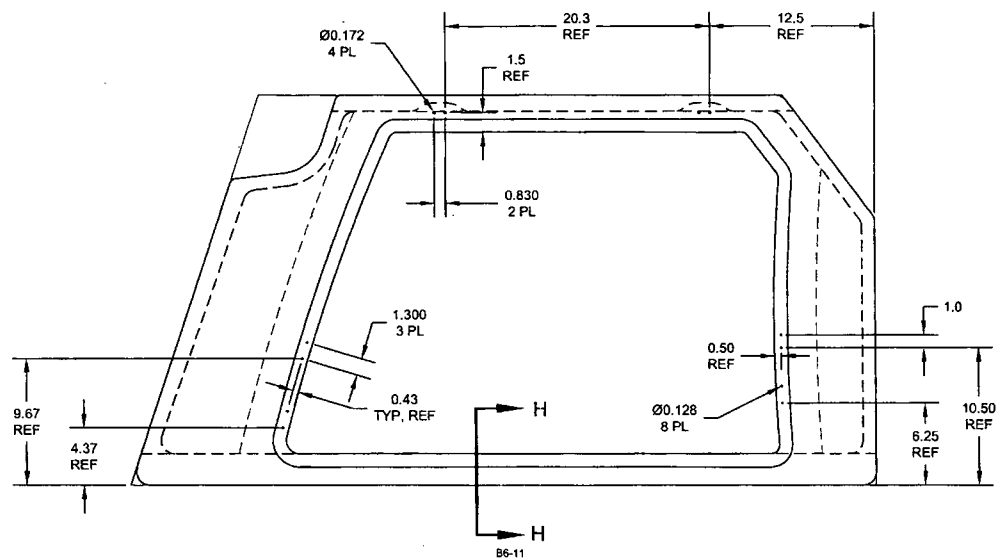
**RELEASED**  
2009-10-20  
*WJ*

**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

- NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEW

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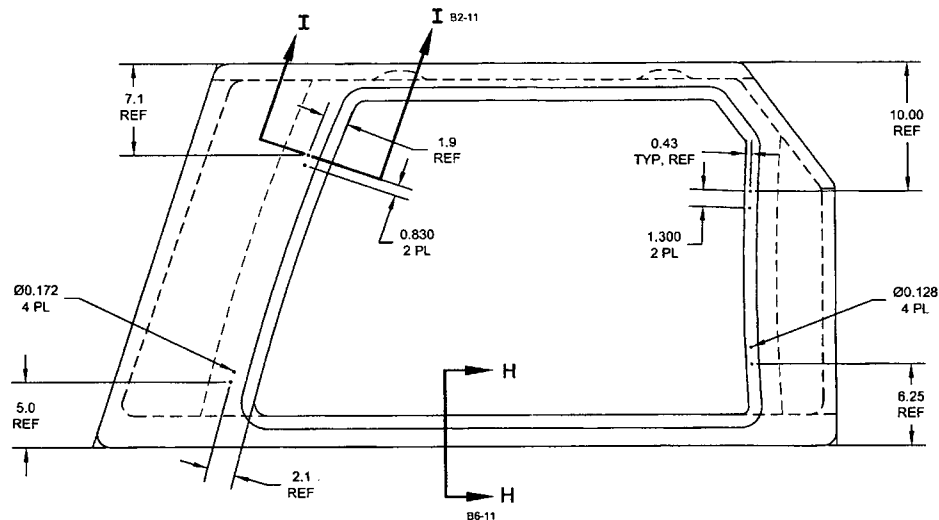
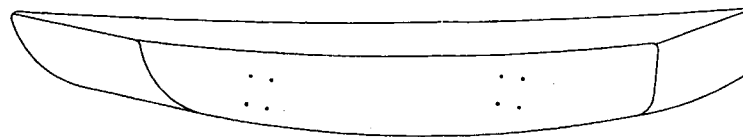
**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

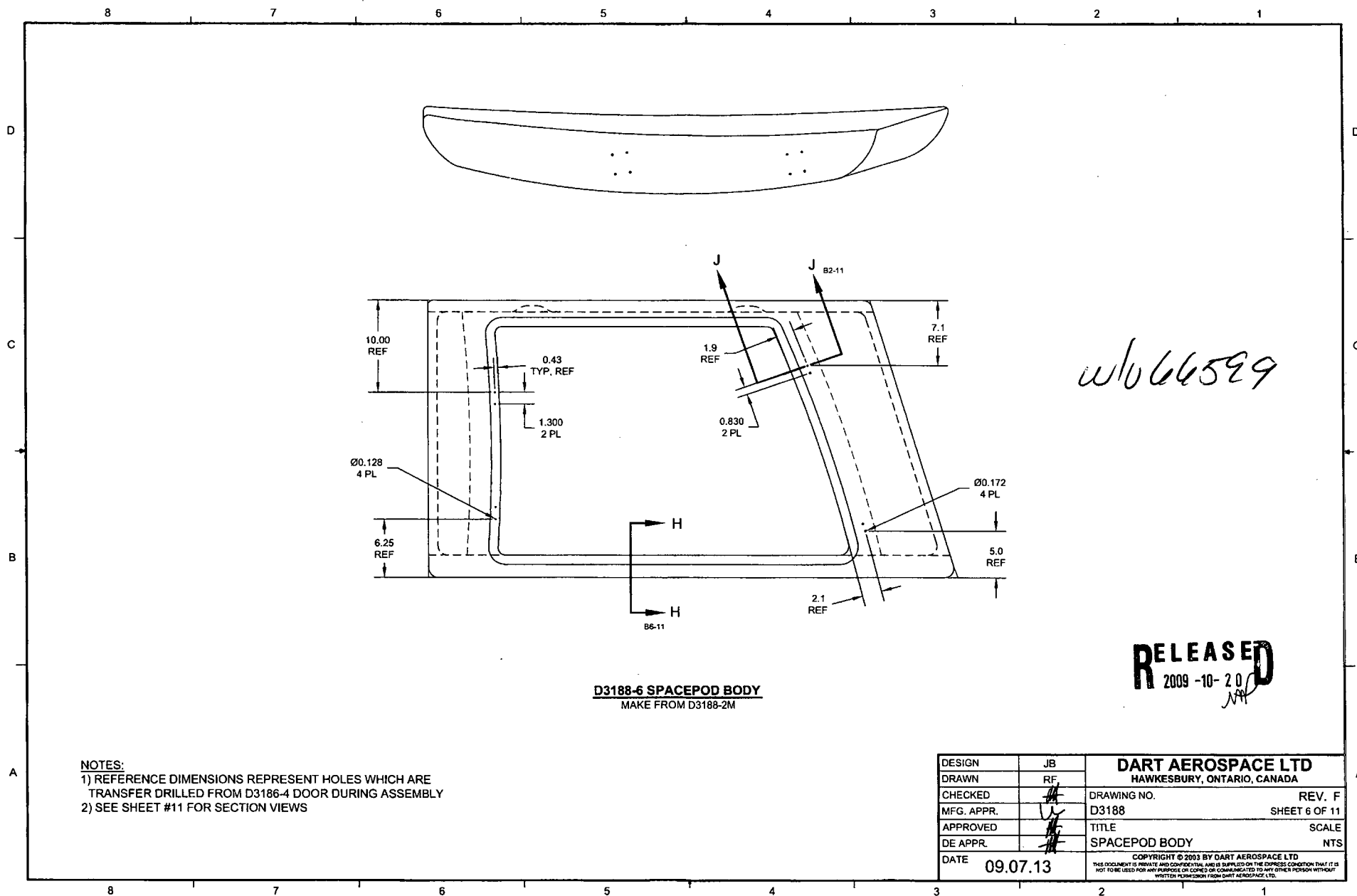
u6 66599

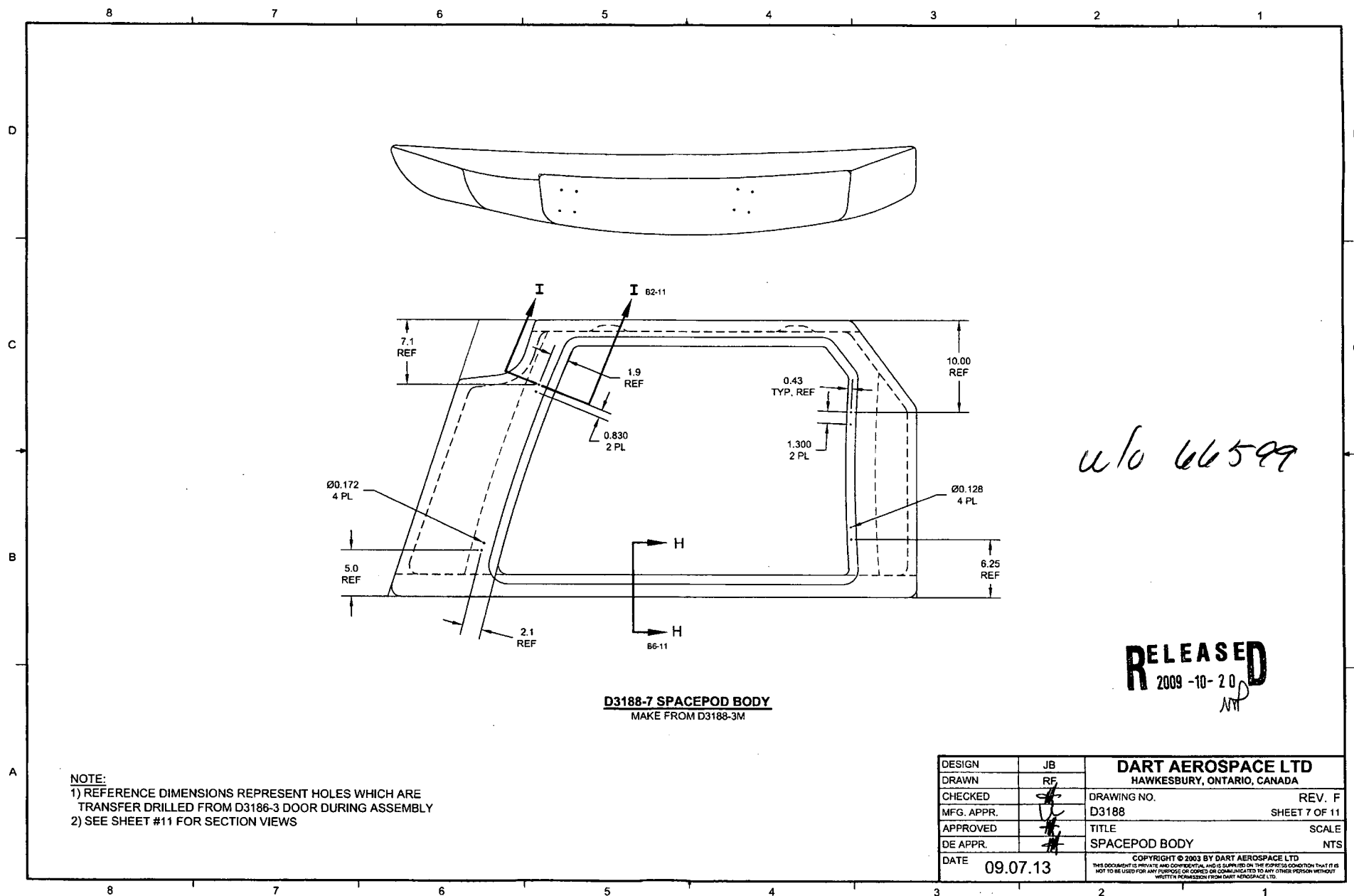
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2009-10-20

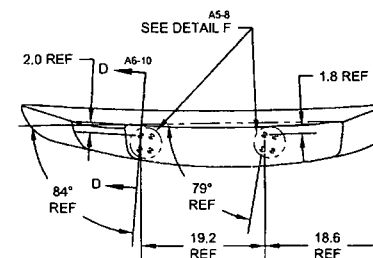
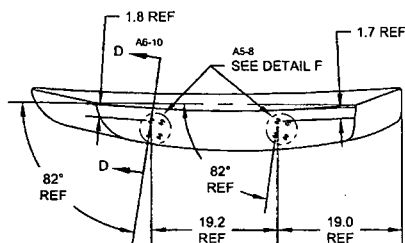
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

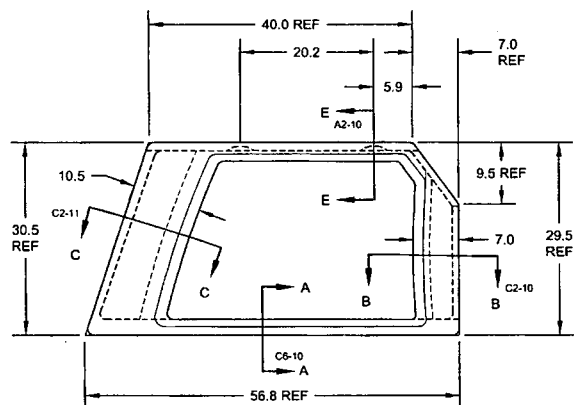
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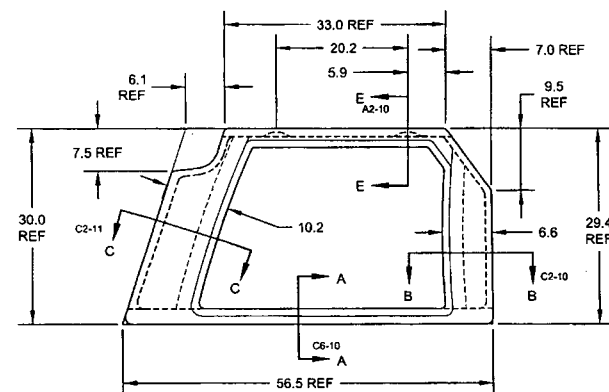




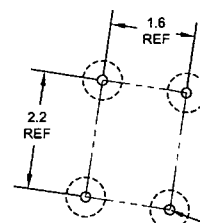
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**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**







**DETAIL F**

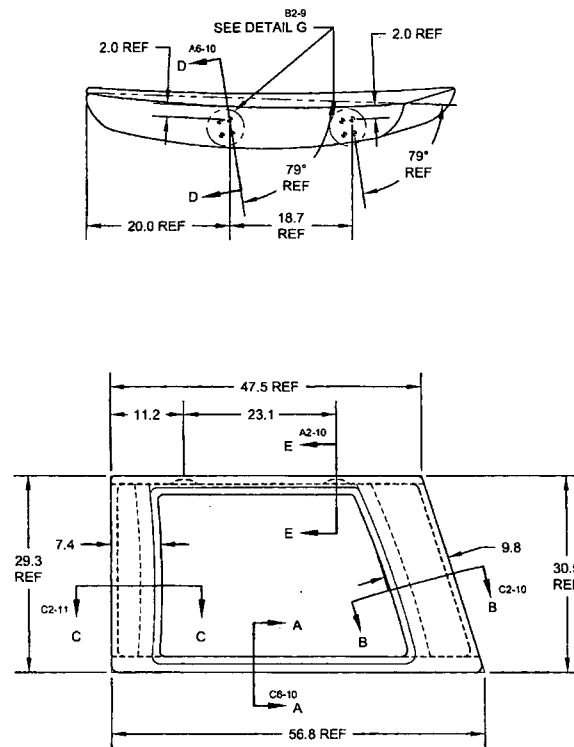
INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A5-10  
D3-8  
D7-8

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2009-10-20

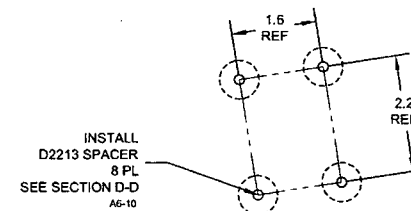
**D3188-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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**D3188-2M SPACEPOD BODY**







**DETAIL G** D6-9

w/046529

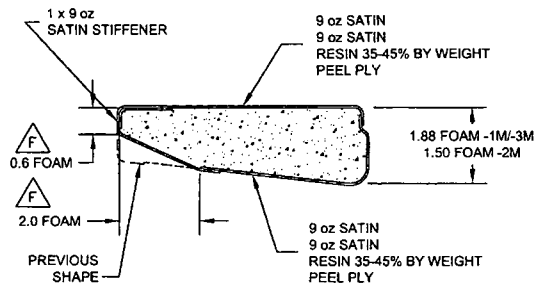
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**D3186-2M NOTES:**

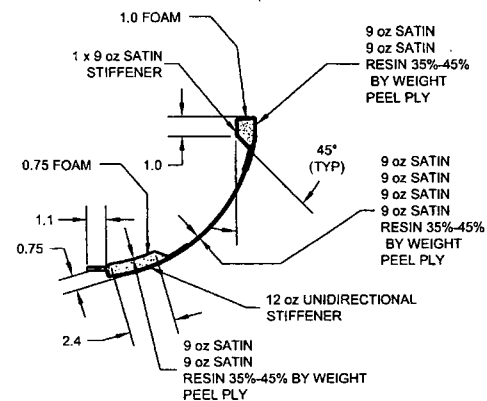
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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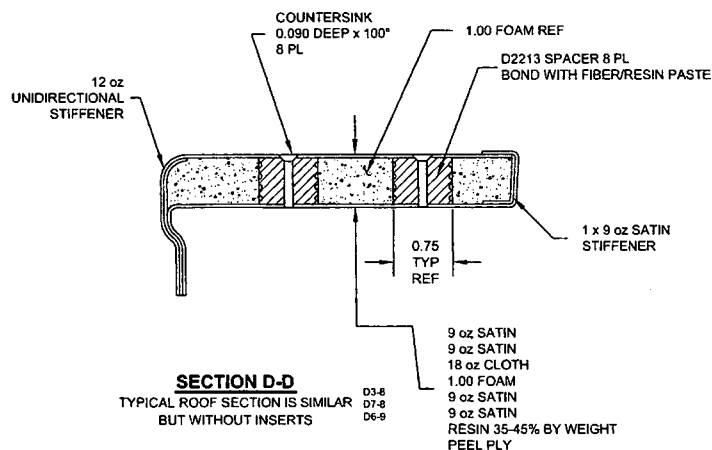
OUTBOARD



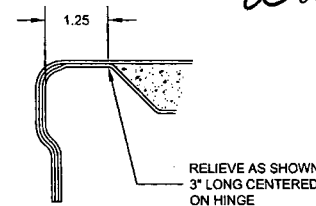
**SECTION A-A**  
TYPICAL FLOOR SECTION  
B7-8  
B3-8  
B6-9



**SECTION B-B**  
SECTION C-C OPPOSITE  
B6-8  
B6-8  
B4-8  
B2-8  
B7-8  
B5-9



**SECTION D-D**  
TYPICAL ROOF SECTION IS SIMILAR  
BUT WITHOUT INSERTS  
D3-8  
D7-8  
D6-9

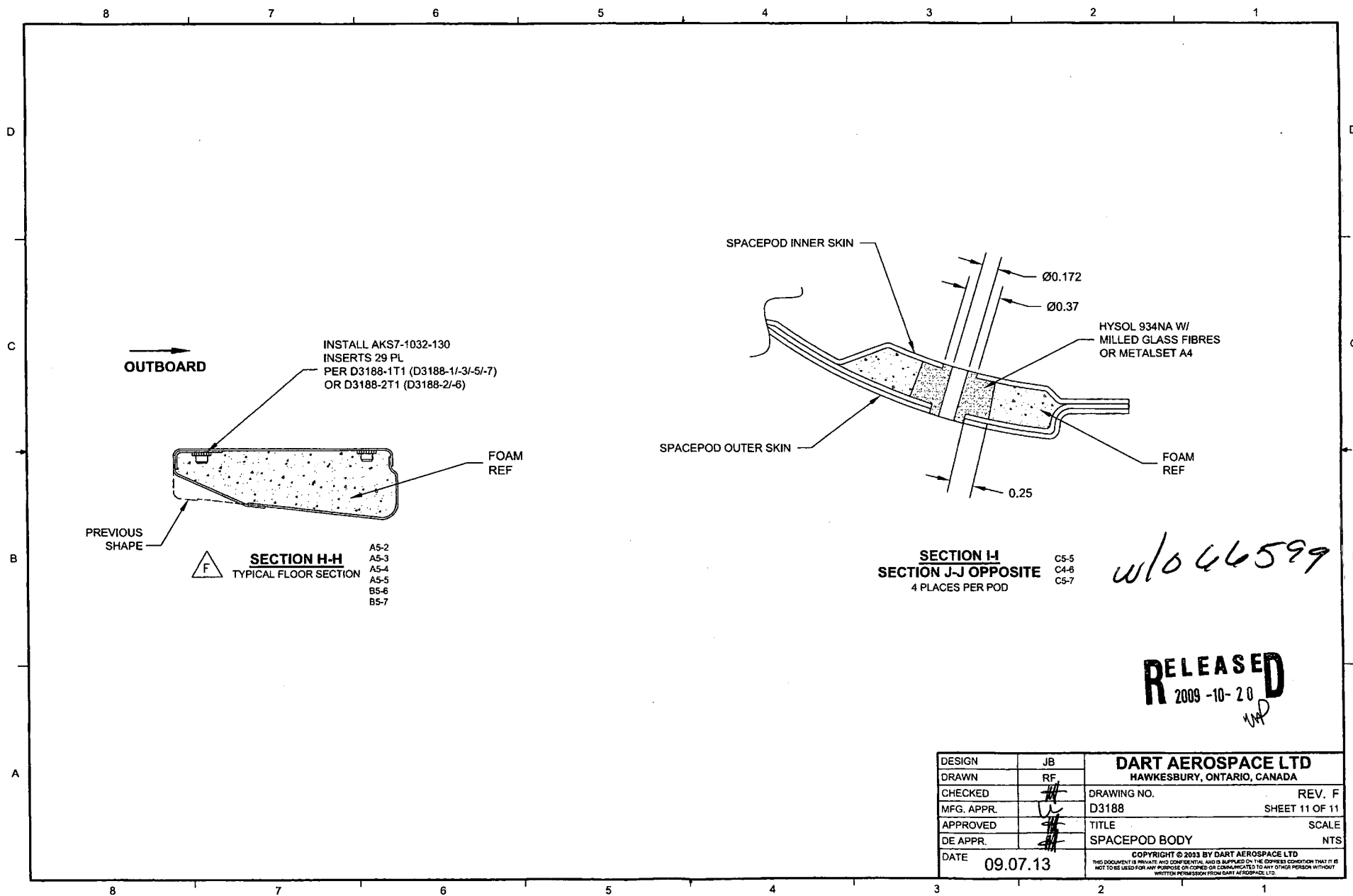


**SECTION E-E**  
2 PLACES PER POD  
C2-8  
C7-8  
B6-9

4646599

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2009-10-27  
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